

Work Order ID 84452

May-11-12 3:27:05 PM

84452

PRELIMINARY ISSUE

Page 1

Item ID: D4483-1
Revision ID: U/R
Item Name: Fwd Closeout Panel

Accept

N900040100

Setup Start

NS1

Stop

NS2

Start Date: 11/05/2012 Start Qty: 5.00
Required Date: 11/05/2012 Req'd Qty: 5.00

5

5

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MCT
QC:

Date: 12/05/14
Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4483

PAT

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

6061.063

1-Cut as per Dwg
Dwg Rev: P131
Prog Rev: P131
2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00 - inspector to P131

120

QC

Memo

0.00

Quality Control

Dwg only
5/17/13



NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data <input type="checkbox"/>												
Equip/Tooling <input type="checkbox"/>												
Operator <input type="checkbox"/>												
Material <input type="checkbox"/>												
Setup <input type="checkbox"/>												
Other <input type="checkbox"/>												
Process <input type="checkbox"/>												
Supplier <input type="checkbox"/>												
Training <input type="checkbox"/>												
Unapproved <input type="checkbox"/>												
FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <hr/> <hr/> <hr/>		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other <hr/> <hr/> <hr/>	

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Page 2

Item ID: D4483-1

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Item Name: Fwd Closeout Panel

Start Date: 11/05/2012 Start Qty: 5.00

Required Date: 11/05/2012 Req'd Qty: 5.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

130

130

Brake NC

Brake NC

Operation
Description

Bend as per dwg
NC BRAKE

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

160

160

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

***165** prime part according to QSI 005
4.2.1.3.2 Tempo grey 4500 PB-40B

QC 14/12/09 25 (3)

AB 12-9-24 (3)



NCR: Yes / No

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QA Closed: _____ Date: _____

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Work Order ID 84452

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Page 3

Item ID: D4483-1
Revision ID: U/R
Item Name: Fwd Closeout Panel

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 11/05/2012 Start Qty: 5.00 ***5***

Required Date: 11/05/2012 Req'd Qty: 5.00 ***5***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/
Work Center ID

170
170
Powdercoat
Powder Coating

Operation
Description

Gloss Grey (4.3.5.15) per QSI 005 4.3

Set Up/
Run Hours

0.00

Memo

START TIME: _____
OVEN TEMPERATURE: _____
FINISH TIME: _____

0.00

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

180
180
QC
Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

N/A 4/11/12 05.16

190
190
Packaging
Packaging

Identify as per dwg & Stock Location: *Med*

Fab

0.00

Memo

0.00

13-03-20

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY												
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Work Order ID 84452

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84452

Page 4

Item ID: D4483-1
 Revision ID: U/R
 Item Name: Fwd Closeout Panel
 Start Date: 11/05/2012 Start Qty: 5.00
 Required Date: 11/05/2012 Req'd Qty: 5.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: Date:
 QC: Date:

Tooling: Date:
 SPC (Y/N): Date:

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/
 Work Center ID
 200
200
 QC
 Quality Control

Operation
 Description
 QC21- Final Inspection - Work Order Release

Set Up/
 Run Hours
 0.00

Memo

0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

13/3/26 JF
 MK

13-1-17

POSITIVE RECALL

EFFECTIVE 12/5/30 AUTH

RELEASED DATE

8 13/3/26 Reoc

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Doc/Data <input type="checkbox"/>											
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FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge _____ _____ _____	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____

Picklist Print

May-11-12 3:27:08 PM

Page 1

Work Order ID: 84452

84452

Parent Item: D4483-1

D4483-1

Parent Item Name: Fwd Closeout Panel

Start Date: 11/05/2012

Required Date: 11/05/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 11.12.12 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No		100	sf	365.8922	0.6721	3.537368			

M6061T6S 063

**

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT021

365.8922000

113608

0

116308

6.01556842

117285

67.544

119331

44.2

119802

18.94

120218

19.5

120866

66.9426316

121578

142.75

121805

121805

Jm

12-5-8

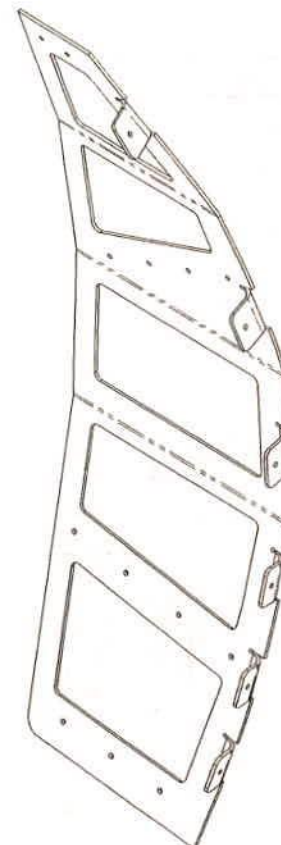
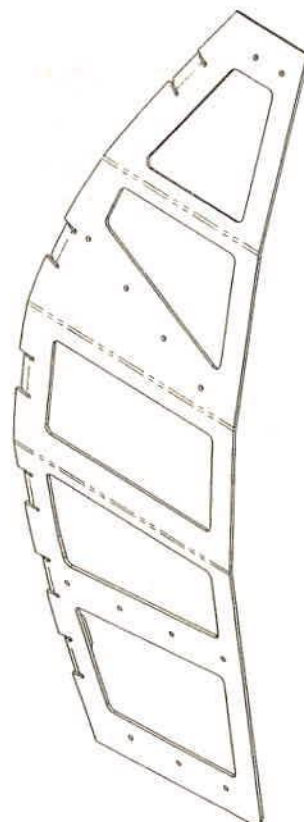
NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
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D4483-1 FWD CLOSEOUT PANEL (LOWER DOOR)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 84452 HCS

12/05/14

NOTES:

- 1) MATERIAL: MAKE FROM D4483-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs

PRELIMINARY B1
12.05.08 (AJS)

PB1	GENERAL REVISION SEE REV. A FOR DETAILS.		AJS	12.05.08
A	NEW ISSUE		AJS	12.03.02
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED			DRAWING NO.	REV. PB1
MFG. APPR.			D4483	SHEET 1 OF 3
APPROVED			TITLE	SCALE
DE APPR.		FWD CLOSEOUT PANEL		NTS
DATE	12.05.08	COPYRIGHT © 2013 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON OR ORGANIZATION WITHOUT PERMISSION FROM DART AEROSPACE LTD.</small>		

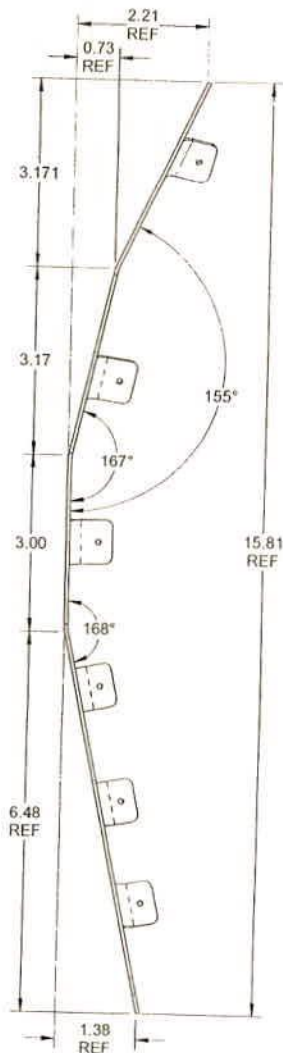
NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

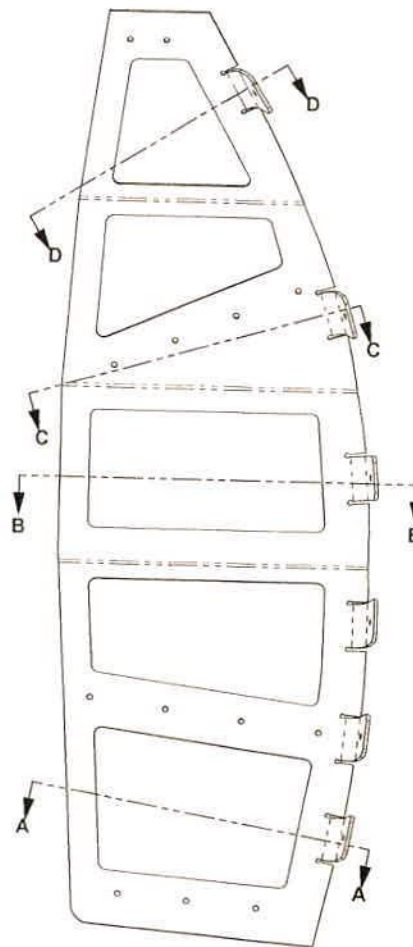
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FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge _____ _____ _____		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other



D4483-1 FWD CLOSEOUT PANEL (LOWER DOOR)



SECTION A-A
(3 PL)

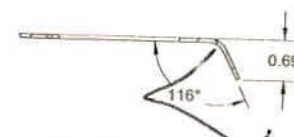
84452



SECTION B-B



SECTION C-C

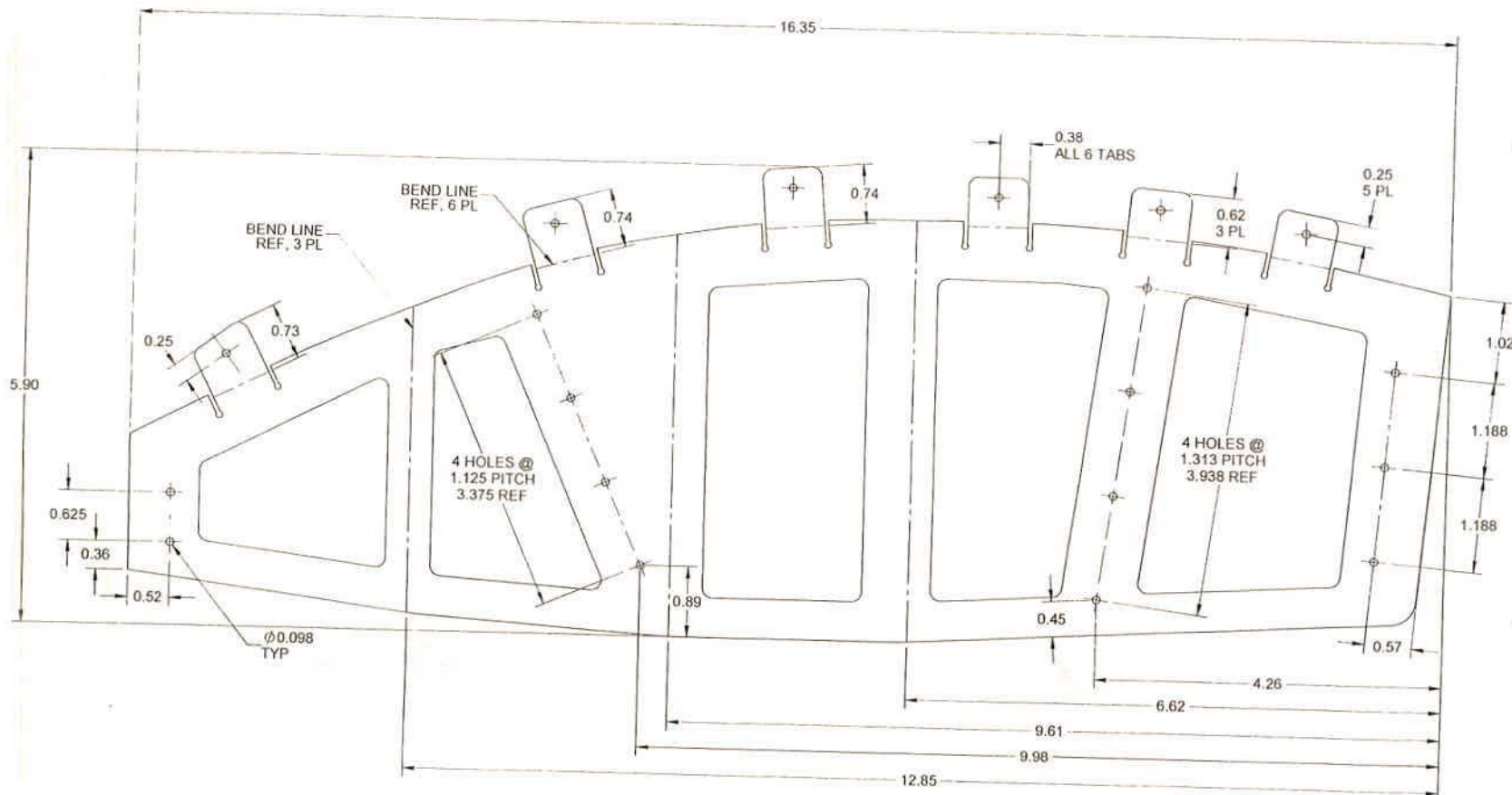


SECTION D-D

ASSISTANT BAND RAIL
0.25

PRELIMINARY B1
12.05.08 (AJS)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D4483	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FWD CLOSEOUT PANEL	NTS
DATE	12.05.08	COPYRIGHT © 2012 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4483-1F FWD CLOSEOUT PANEL (LOWER DOOR)
(FLAT PATTERN)

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs
- 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D4483-1F-REVPB1.DXF"

PRELIMINARY B1
12.05.08 (AJS)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D4483
MFG. APPR		REV. PB1 SHEET 3 OF 3
APPROVED		TITLE FWD CLOSEOUT PANEL
DE APPR		SCALE NTS
DATE	12.05.08	COPYRIGHT © 2012 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO IT IS TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order: 84452
Description: Fwd Closeout Panel	Part Number: D4483-1	
Inspection Dwg: D4483 Rev: PBI	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
φ 0.098	+0.004 -0.001	0.098	✓		✓	mm01
5.90	±0.030	5.895	✓		✓	mm01
16.35	±0.030	16.35	✓		MT	HB-01
0.625	±0.030	0.63	✓		✓	mm01
0.36	±0.030	0.360	✓		✓	mm01
0.52	±0.030	0.524	✓		✓	mm01
0.25	±0.030	0.256	✓		✓	mm01
Bend 0.73	±0.030					
Bend 0.74	±0.030					
Bend 0.74	±0.030					
Bend 0.38	±0.030	0.383	✓		✓	mm01
0.62	±0.030					
0.25	±0.030	0.257	✓		✓	mm01
1.125	±0.010	1.129	✓		✓	mm01
3.375	±0.010	3.379	✓		✓	mm01
1.313	±0.010	1.312	✓		✓	mm01
3.938	±0.010	3.944	✓		✓	mm01
0.89	±0.030	0.870	✓		✓	mm01
0.45	±0.030	0.456	✓		✓	mm01
0.57	±0.030	0.568	✓		✓	mm01
1.02	±0.030	1.023	✓		✓	mm01
1.188	±0.010	1.186	✓		✓	mm01
1.188	±0.010	1.187	✓		✓	mm01

Measured by: Jm	Audited by: G	Prototype Approval:	N/A
Date: 12-5-31	Date: 12/5/31	Date:	N/A
Rev A	Date	Change	Revised by
		New Issue	KJ/JLM
			Approved

Receiving Report

Date:

Batch No:

Supplier:

Dart P/O:

Packing Slip:

Yes

☒ No

Invoice:

Yes

No

Receipt:

Cash

Cr

Release Note Attached:

Yes

✓ No

N/A

Waybill Attached:

Yes

No

Shipment Complete:

Yes

No

QC6 Inspection

Work Order

N/A

N/A

N/A
N/A

N/A

Discrepancies

Discrepancies						Comments
Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	
	VOM P.O. PWA B D					

Initials of receiver (if shipment OK) Level 12

Production/Admin:

Date _____

Received/Costing

Initial

Location

Purchase Order Receipt Listing

Tuesday, May 22, 2012 8:15:48 AM

Page 1 of 1

All amounts are calculated in domestic currency.

All Vendors PO ID PO16995 Receipt Dates from 5/22/2012 to 5/22/2012 All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M/ Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name VC-COP001 Thyssenkrupp Materials CA Ltd											
PO16995	9		M6061T6S.063	sf	5/23/2012	5/22/2012	480.0000	\$2.47	0.0000	0	\$1,184.09
CAD	No		6061-T6 .063 Sheet	sf	480.0000	DESJ02		\$1,184.09	0.0000	0	
			121805								

Total Received Quantity: 480.0000
Total Qty to Inspect (PO U/M): 0.0000
Total Reject Quantity: 0.0000
Total Receipt Value: \$1,184.11
Total Balance Due Quantity: 0.0000



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO16995

Purchase Order Date 5/16/12

PO Print Date 5/17/12

Page Number 3 of 4

Order From :

VC-COP001

THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL"A"
TORONTO, ON M5W 5V8
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	905 669 9444	Requisition Nbr	
Vendor Fax	905 738 9033	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Special Inst: MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AS PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR AMS 4160 OR ASTM B211 OR ASTM B221

7	M6061T6B1.000X04.000	6061-T6 Bar 1.00 x 4.00	5/23/12	12.00	Yours ppd	\$9.4200	\$113.04
			Yes		f		

Special Inst: MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AS PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR AMS 4160 OR ASTM B211 OR ASTM B221

9	M6061T6S.063	6061-T6 .063 Sheet	5/23/12	480.00	Yours ppd	\$2.4792	\$1,190.00
			Yes	sf			

021

Special Inst: MATERIAL: 6061-T6/T62 ALUMINUM SHEET
AS PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209

10	M304S16GA	304/316 Sheet .063	5/23/12	128.00	Yours ppd	\$4.5141	\$577.80
			Yes	sf			

No substitution or deviation without consent.
Certificate of Conformity or Material Certification required when applicable

Change Nbr: 2

Change Date: 5/17/12

B I L L O F L A D I N G

No: PEC 767877

Ship From:
THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 9057389033

Ship Date 18May12 at 14:12 From PFW
Probill
Via VIM TRANSFER
FOB CONCORD
Frt PREPAID
Route 0- 0 Manifest
Vhcle Trailer
Slp STAN IVERS (905-532-1350)
Sold To: (20115)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7

Ship To: (1)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
Tel: 613-632-9577 Fax: 613-632-1053

B I L L O F L A D I N G

1) Our Order PEC-451956- 1 Your PO # 16995
ALUMINUM SHEET 6061 T6
.0640 Nom X 48.0000" X 144.0000"

Heat Number	Tag No	Quantity	PCS	Wt LBS
25516/01/00	68126	480.00 SFT	10	418

TOTAL:	Tags	PCS	LBS
	1	10	418

ADD ON TO 451875/451877 SUR-CHARGE PAID

MILL TEST REPORTS, PACKING SLIPS ARE TO SENT
WITH MATERIAL AND FAXED TO THE CUSTOMER PRIOR
TO SHIPPING.

ATTN: CHANTAL/LINDA

** ALL PACKING SLIPS MUST HAVE THE HEAT NUMBER **
** REFERENCED ON IT **

TOTAL OF 1 SKID GR.W. 690 LBS

*CUSTOMER PICK-UP HRS AT THYSSENKRUPP MATERIALS NA
CONCORD, ONT.* *** 9:00 AM TO 4:00 PM ***

**** TEL. 800-926-2600 ****

* WE STOCK STAINLESS STEEL *

* PLEASE LET US QUOTE YOUR NEXT REQUIREMENT *

***PLEASE NOTE A \$25.00 ENERGY SURCHARGE WILL BE

Page: 1Continued

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE
RAPPORTÉES IMMÉDIATEMENT.

ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY

RETOUR DE MARCHANDISES AVEC NOTRE NUMERO D'APPROBATION SEULEMENT.

MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER.

18 MAY 2012

DATE

THYSSENKRUPP MATERIALS NA

DART AEROSPACE

ALUMINUM SHEET 6061 T6
.0640 Nom X 48.0000" X 144.0000"
PART NO.

PO/Rel 16995

We certify that this is a true copy of the report
furnished by the producer of the metal, or data
resulting from tests made in approved labs.

Certificate of Mill Test Results

BL PEC-767877-001

18May12

Signed by: _____

Pg 1/2



Abnahmeprüfzeugnis 3.1 (EN 10204) Inspection certificate – mill certificate

Nr.: 85294543 01 / 7

Rev. 0

Seite / page: 1 von / of 2

Datum / date: 2011 12 12

Zertifiziert nach / certified to ISO 9001, ISO/TS 16949, EN/AS 9100, ISO 14001, NADCAP

Auftraggeber / customer: ThyssenKrupp Materials NA 2821 Langstaff Rd CDN-L4K 5C6 CONCORD, ON Warenempfänger / consignee: ThyssenKrupp Materials NA 2821 Langstaff Rd CDN-L4K 5C6 CONCORD, ON Endkunde, Bestell-Nr. / Your cust., ord. no.:	Bestell Nr. / order no.: PEC-234982 Datum / date: 2011 11 23 Auftragsbest. Nr. / order confirm. no.: 633961 Datum / date: 2011 11 24 Lieferschein Nr. / delivery note: 85294543 Datum / date: 2011 12 30 Akkreditiv Nr. / letter of credit no.:
---	--

Produkt/product Form / form: Sheet Werkstoff / material: 6061 Zustand / temper: T6 Dim. / dim: [inch]: 0,063x48,00x144,00 Kundenartikel-Nr / customer article no.:	Bedingungen/terms Techn. Lieferbedingungen / techn. spec.: AMS-QQ-A-250/11, 08.1997 ASTM B 209 - 07 Material meets also the mech. properties of AMS 40271J, 07.2008, but not marked ANSI H35.2-2009 ASME SB 209, 2007 Sondervorschrift / special terms:
---	--

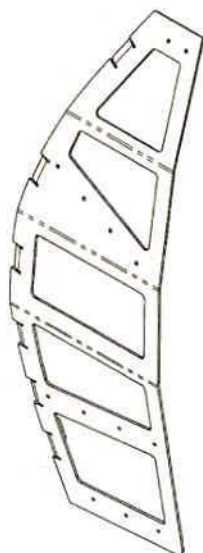
AB-Pos. ord.-item.	BNr/Los/Teillos Lot/No./Part	Guss Nr. cast no.	Werkstoff material	Kollo packno.	Gewicht netto weight net	Stk. pcs.
01	25516/01/00	01/0046886/1	6061.1	6339610001	4010,141 lbs	97

Chemische Zusammensetzung / chemical composition: [%] Gewichtsanteile / weight proportion (OES)											
Guss Nr. / cast no.	AMAG designation	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	
01/0046886/1	6061.1 actual	0,65	0,50	0,21	0,13	0,88	0,15	0,01	0,05	0,06	

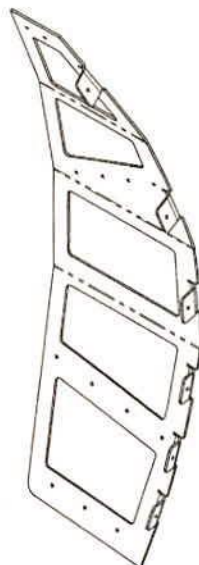
Zugversuch / Tensile test									
BNr/Los Lot/No.	Zustand temper	Richtung direction			Rm [ksi]	Rp0.2 [ksi]	A2" [%]		
25516/01	T6	LT			46,6	38,1	16		
25516/01	T6	LT			46,6	38,1	16		
25516/01	T6	LT			46,4	38,1	16		
25516/01	T6	LT			46,6	38,3	17		
25516/01	T6	LT			46,6	38,3	16		
25516/01	T6	LT			46,6	38,3	16		
25516/01	T6	LT			46,7	38,4	15		
25516/01	T6	LT			46,7	38,3	16		

amf 12/05/22

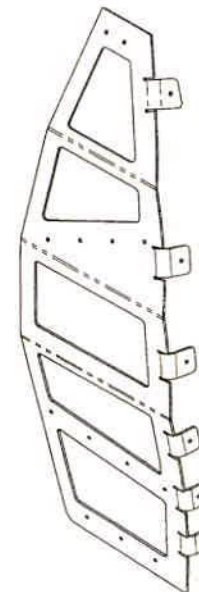
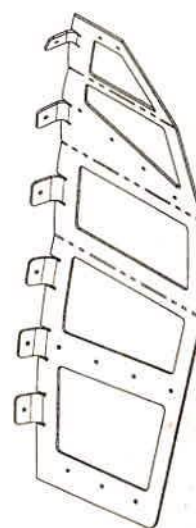
AMAG rolling GmbH, Postfach 32, A-5282 Ranshofen, Österreich – www.amag.at
 AMAG rolling GmbH, P.O. Box 32, A-5282 Ranshofen, Austria – www.amag.at



D4483-1 FWD CLOSEOUT PANEL (LH)



D4483-2 FWD CLOSEOUT PANEL (RH)

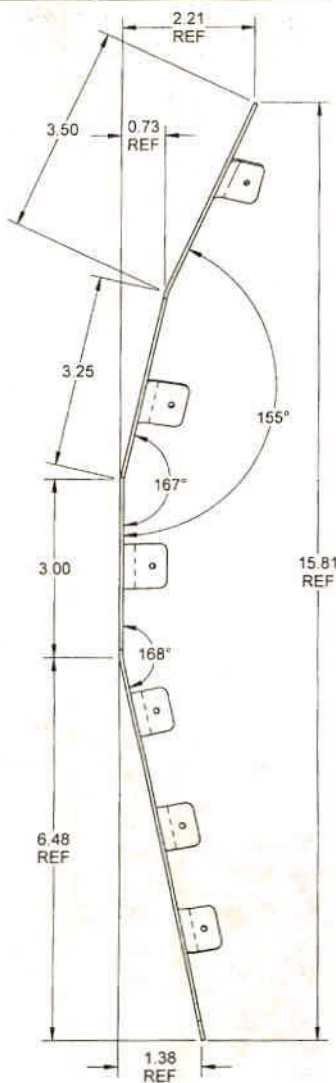


NOTES:

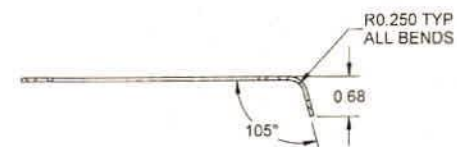
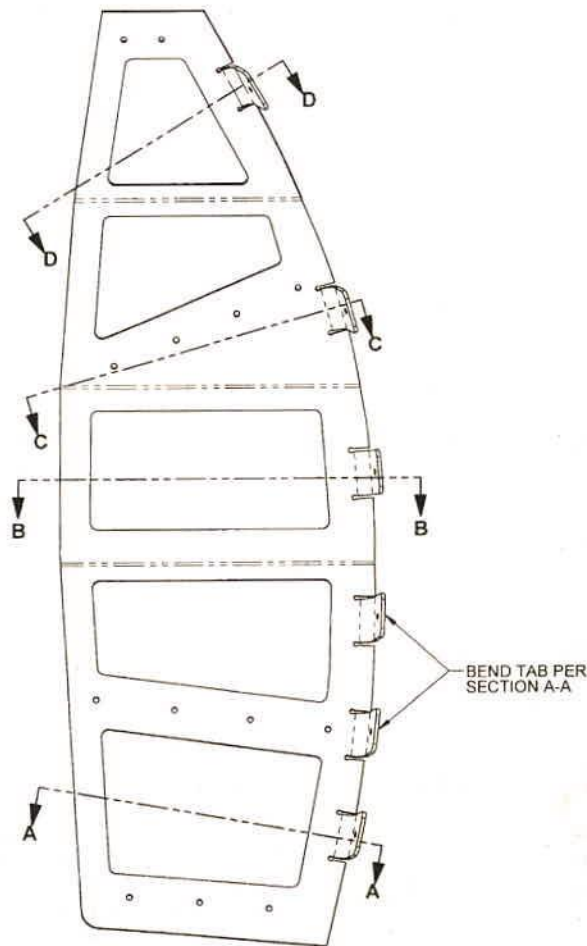
- 1) MATERIAL: MAKE FROM D4483-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs

RELEASED
2012-11-29
MJP

C	ADDED - 2 (RH CONFIGURATION)	AJS	12.10.05
B	GENERAL REVISION SEE REV. A FOR DETAILS. PRIMER NOTE ADDED	AJS	12.09.11
A	NEW ISSUE	AJS	12.03.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	N	D4483	SHEET 1 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	FWD CLOSEOUT PANEL	NTS
DATE	12.10.05	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY REASON OTHER THAN THAT FOR WHICH IT WAS SUPPLIED WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4483-1 FWD CLOSEOUT PANEL (LH)



SECTION A-A
(3 PL)



SECTION B-B



SECTION C-C

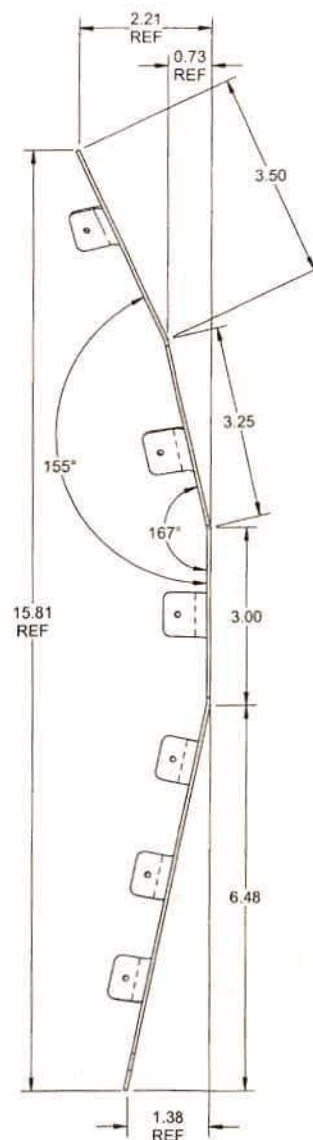


SECTION D-D

RELEASED
2012-11-29

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO	REV. C
MFG APPR.	<i>[Signature]</i>	D4483	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD CLOSEOUT PANEL	NTS
DATE	12.10.05	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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D4483-2 FWD CLOSEOUT PANEL (RH)



R0.250 TYP
ALL BENDS



SECTION E-E
(3PL)



SECTION F-F



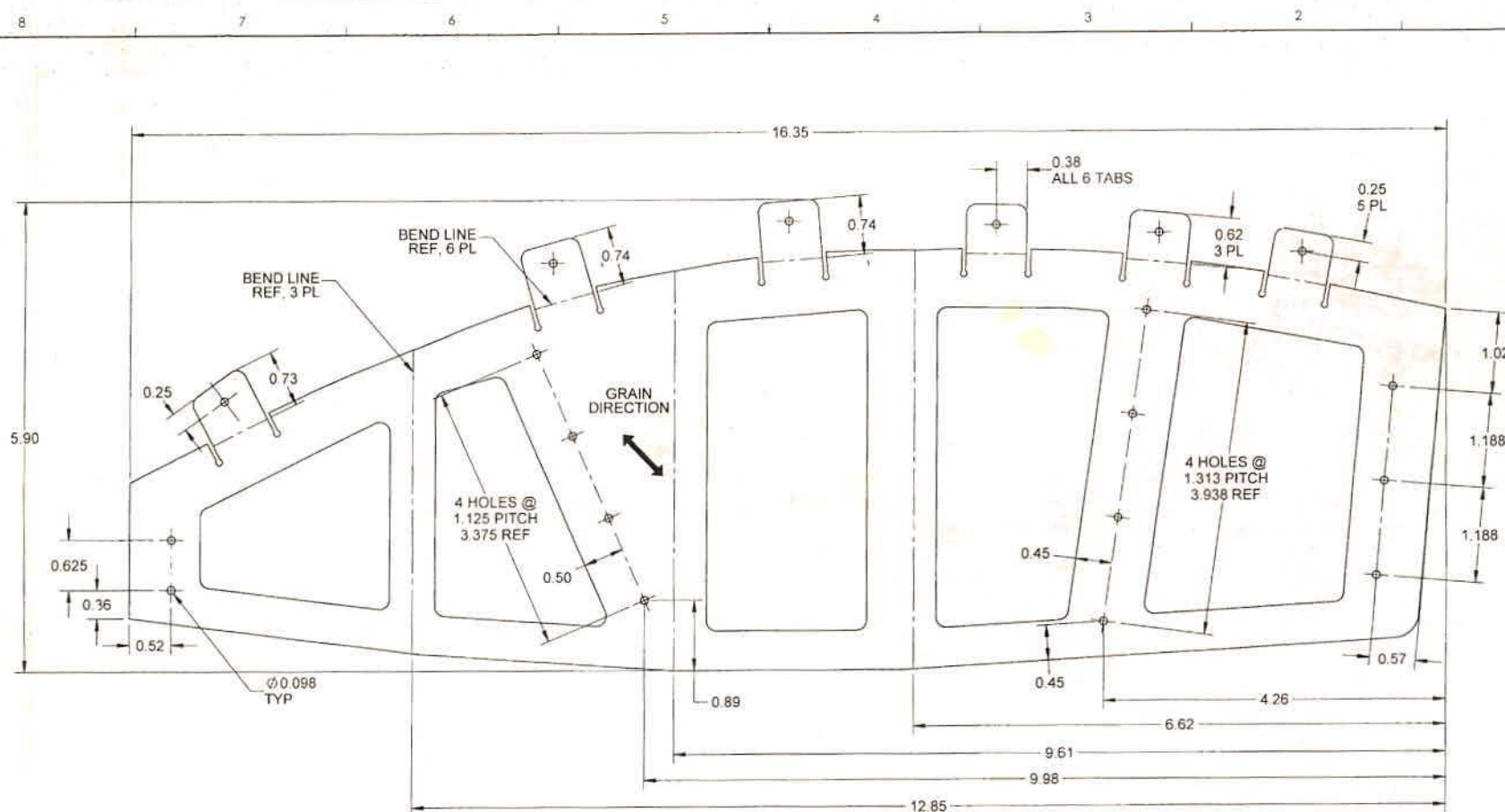
SECTION G-G



SECTION H-H

RELEASED
2012-11-29
WJP

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JS	D4483	SHEET 3 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	FWD CLOSEOUT PANEL	NTS
DATE	12.10.05	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	



D4483-1F FWD CLOSEOUT PANEL
(FLAT PATTERN)

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs
- 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D4483-1F-REV.C.DXF"

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG APPR.	<i>[Signature]</i>	D4483	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD CLOSEOUT PANEL	NTS
DATE	12.10.05	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
2012-11-29
[Signature]